

Date: Friday, 06/02/2009 11:28:59 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 FLOOR PROTECTOR (PILOT)
Job Number	: 45593	Part Number	: D38742
Estimate Number	: 13788	Drawing Number	: D3874-2
P.O. Number	:	Project Number	: IN0002
This Issue	: 06/02/2009 S.O. No. :	Drawing Revision	: PROTOTYPE 09.04.21 <i>DL</i>
Prsht Rev.	: NC	Material	: To Be Determined
First Issue	: 06/02/2009 Type : R&D THERMOFORMING	Due Date	: 16/02/2009 Qty: 2 Um: Each
Previous Run	:		
Written By	:		
Checked & Approved By	: <i>JUP 09.02.06</i>		
Comment	: Est. Rev. A 09.02.06 New Issue DL		

Additional Product

PROTOTYPE
ENGINEERING
APPROVAL

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

0.0	LEXANST25 <i>LEXS 118 90318 08</i> 1/8" Lexan Sheet	
-----	--	--

*M 110566**PTO*

Comment: Qty.: *8.0000* sf(s)/Unit Total: 16.0000 sf(s)
1/8" Lexan Sheet *Tot. 8.36 sf.*

1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

09/02/06 DL

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------

*(x2)*

Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

09/02/06 DL

3.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3874-2 and folio (38742 Prototype) using tool DT 9457

Dwg. Rev. *PROTOTYPE*
Folio Rev. *A*

09/02/06 DL

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

09/02/06 DL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
04/02/06	0.0.	MATERIAL .118 Textured LEXAN. Sample Supplied by Sabic DO NOT DRAW MAT FROM STOCK					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 06/02/2009 11:28:59 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 FLOOR PROTECTOR (PILOT)

Job Number: 45593

Part Number: D38742

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BB 09/02/09 (X2)

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/02/09 (X2)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/16 (X2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



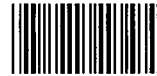
Comment: INSPECT WORK TO CURRENT STEP

BB 09.04.16
I.d AS prototypes

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Eng's testing } # 09.04.21

FOR ENGINEERING USE ONLY

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09.04.22 Prototype

Job Completion



09.06.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

45593

DART AEROSPACE LTD	Work Order: 45592
Description:	Part Number: 03874-1
Inspection Dwg: 03874 Rev: A	Page 1 of 1

03874-2
09.04.22
2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

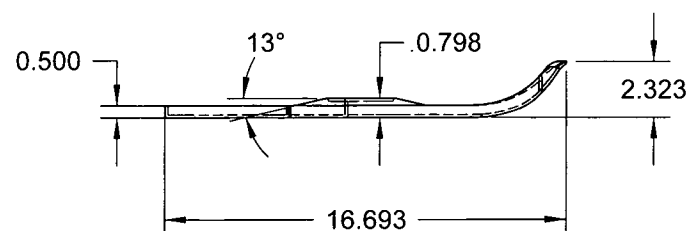
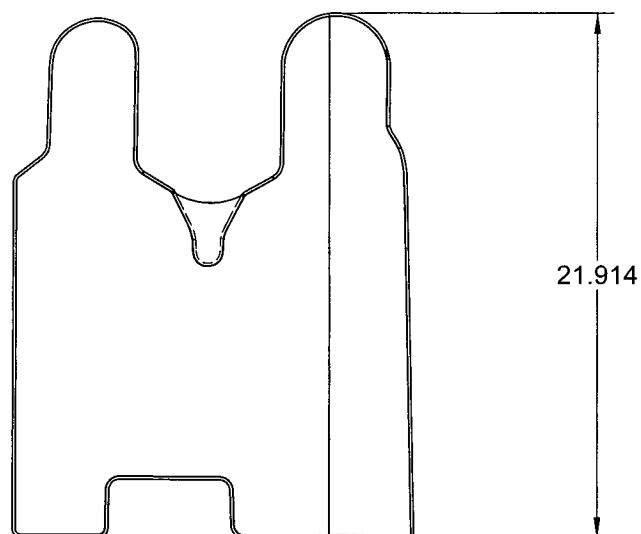
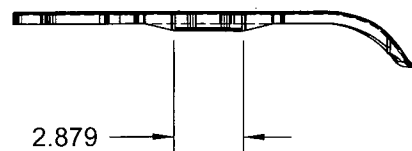
Measured by: BB	Date: 09/04/16
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.9		22	✓			
16.2		17	✓			
.5	Min	.55	✓			
2.3		2.5	✓			
.050	Flange Min	.112	✓			
.070	Bottom Min	.101	✓			
	First					

Measured by: BB	Date: 09/04/16
Audited by: 2	Date: 09.04.16
Prototype Approval: RH	Date: 09.04.20

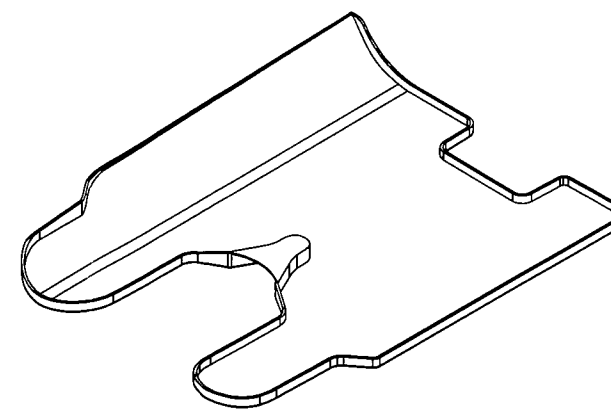
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.118" THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: lbs
- 8) TOOLING: THERMOFORM PER MOLD DT _____ PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: _____ " UNLESS OTHERWISE NOTED



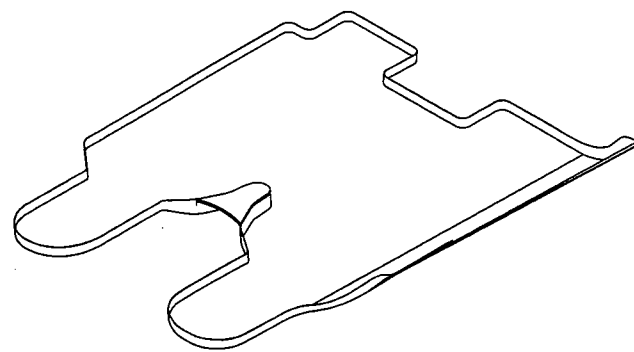
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 455913

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

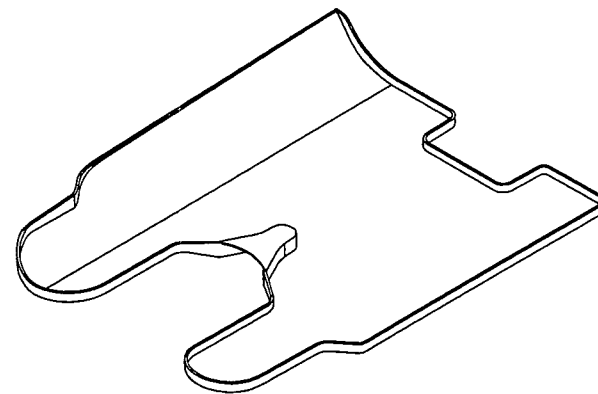
09.02.04 RET

SUPERCEDED ON
09.04.09 RET

DESIGN	<u>RET</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>RET</u>		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3874	SHEET 2 OF 2
APPROVED		TITLE	SCALE
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D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.04.09 PH
SUPERSEDED PH
09.04.20

A	NEW ISSUE		PH	09.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	PH			
CHECKED		DRAWING NO.		REV. A
MFG. APPR.		D3874		SHEET 1 OF 3
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4

3

2

1

D

C

B

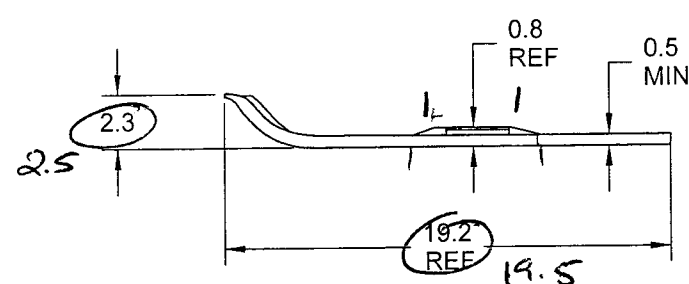
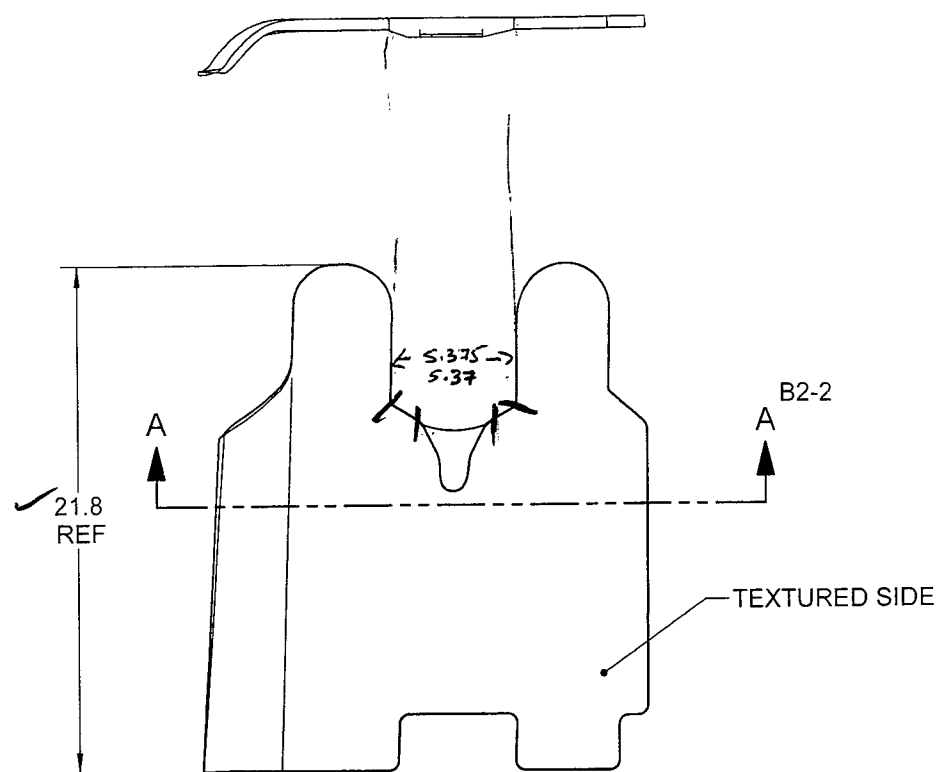
A

D

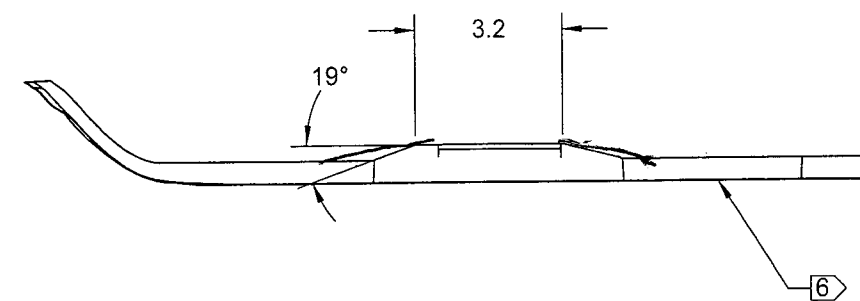
C

B

A



D3874-1 FLOOR PROTECTOR



SECTION A-A SCALE 2X

C5-2

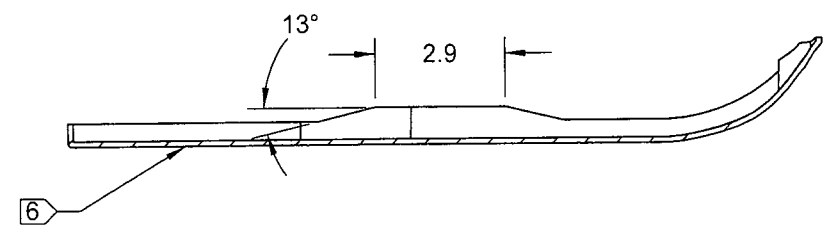
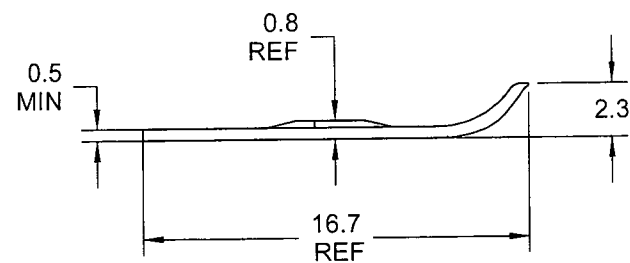
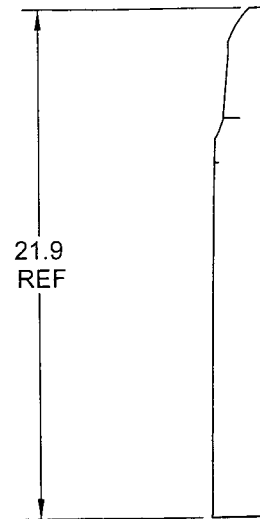
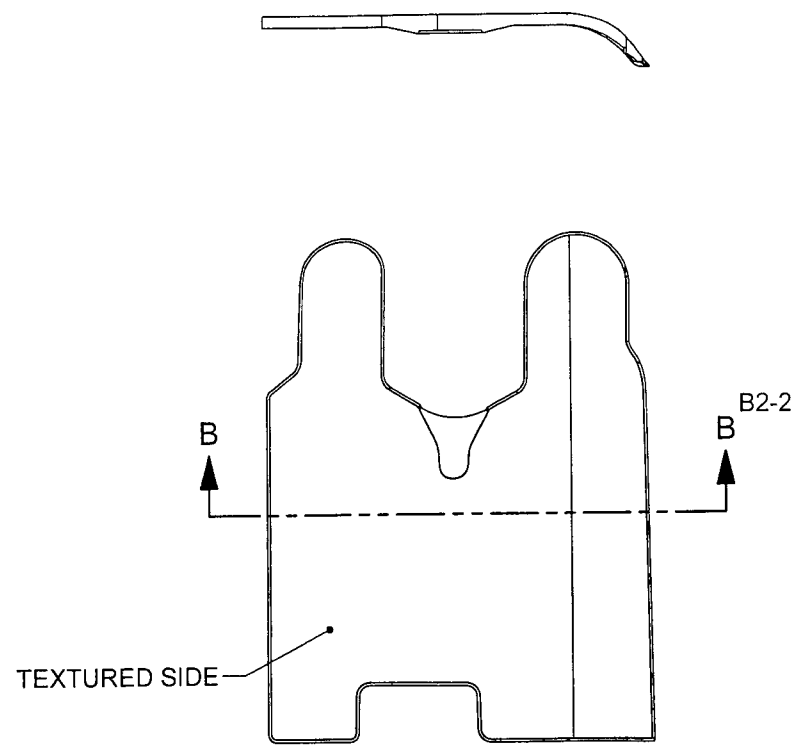
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.04.09 *PH*

SUPERCEDED
PH 09.04.20

NOTES:

- 1) MATERIAL: LEXAN 90318, 0.118 THICK, 112-CLEAR
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.085" ELSEWHERE

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3874	SHEET 2 OF 3
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SECTION B-B
SCALE 2X

D3874-2 FLOOR PROTECTOR

PROTOTYPE
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09.04.09 *RF*
SUPERSEDED
ON 09.04.20 *RF*

NOTES:

- 1) MATERIAL: LEXAN 90318, 0.118 THICK, 112-CLEAR
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.070" ELSEWHERE

DESIGN	<i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RF</i>		
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MFG. APPR.		D3874	SHEET 3 OF 3
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SABIC Polymershapes

سابك
sabic

INVOICE NO.	0085310/M
INVOICE DATE	21.01.09
TAKEN BY	melkertd
G.S.T. REG. NO.	856372750RT0001
CARRIER	

INVOICE

PST 85637 2750 TR000

SOLD TO: DART AEROSPACE LTD

1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7
Canada

SHIP TO: DART AEROSPACE LTD
1270 ABERDEEN ST.
ATTN: LINDA LACELLE
HAWKESBURY ON K6A 1K7
Canada

A/C 22.3

CUSTOMER DARAER		SHIP VIA EPIC		TAX LIC 1 CHARGE GST		TAX LIC 2 6112-5207		INVOICE TERMS NET 30 DAYS		SALES ORDER PAGE 085498 1 99		WHS.		
CUSTOMER P.O. SAMPLE			SHIP DATE 21.01.09		FREIGHT TERMS PREPAID		SALES REP. WADE DIXON		S.D.N. 01		BILL OF LADING		Sch. Date 21.01.09	Sales Office 99
LN	PRODUCT		ORDER	B/O	SHIP	SKU	DESCRIPTION				PRICE	PER	EXTENSION	
001	11201655		1	0	1	SHT	*** SAMPLE REQUEST *** 90318-112 PROTECT A GLAZE .118 X 60 X 96				1 .00	SHT	0.00	
002	0000005		1	0	1	EA	THANK YOU FOR SELECTING SABIC POLYMERSHAPES GST PAYABLE @ 5%				1 .00	EA	0.00	
							PLEASE PAY THIS AMOUNT						0.00	
							=====							
							Balance Outstanding						0.00	
							**** PAID ****							
							RECEIVED JAN 27 2009							

							*** IF YOU ARE NOT CURRENTLY RECEIVING OUR INVOICES ***							
							*** VIA EMAIL OR FAX, PLEASE SUPPLY US WITH AN EMAIL ***							
							*** ADDRESS OR FAX NUMBER . FAX TO 905-789-3161 ***							

							*							

PLEASE Remit To: SABIC Polymershapes 9150 Airport Road Brampton ON L6S 6G1

Phn : (613)745-7043 Fax : (613)745-4291

NO GOODS TO BE RETURNED WITHOUT APPROVAL FROM US. ALL DISCREPANCIES MUST BE REPORTED WITHIN 3 DAYS.

Receiving Report

Date: 09/10/12

Batch No: 110566

Supplier: Sabic Poly.

Dart P/O: ~~7702~~ SAMPLE

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☐
 Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☐ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☐
 Shipment Complete: Yes ☐ No ☐ N/A ☐
 QCS Inspection ☐ N/A ☐
 Work Order ☐ N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	<u>Sample</u>	<u>1</u>	<u>1</u>			

Initials of receiver (if shipment OK) Level 12 CX

Production/Admin:

Date

Received/Costing

Initial

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

FORM FOR SHIPMENT
 SENSITIVE INFORMATION

DISCREPANCIES MUST BE REPORTED WITHIN 3 DAYS
 UNLESS OTHERWISE MARKED ON ALL PACKAGES

SABIC
Innovative
Plastics™

سابك
sabic

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: Jan. 21, 2009

YOUR PURCHASE ORDER: N/A

OUR SHIPPER NO: 085498

INVOICE NO: 0085310

SABIC POLYMERSHAPES LINE ITEM # 001

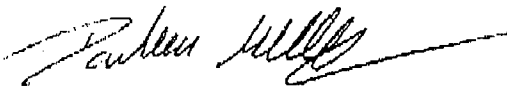
QUANTITY: 1 SAMPLE SHEET

DESCRIPTION: 90318-112 - PROTECT A GLAZE - .118 X .60 X .96

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: UL-94-HB

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

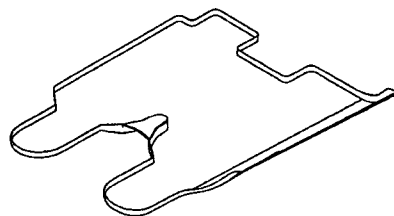
AUTHORIZED REPRESENTATIVE SIGNATURE



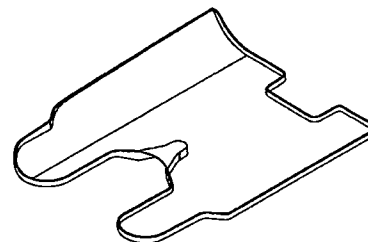
DARLEEN MELKERT
INSIDE SALES REPRESENTATIVE

1450 Old Times Road
Unit 519
Ottawa, Ontario
K1B 5L3

T: 613-745-7043
F: 613-745-4291
E: darleen.melkert@sabic-ip.com
www.sabic-ip.com



D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

SUPERCEDED ON
09.04.22 #

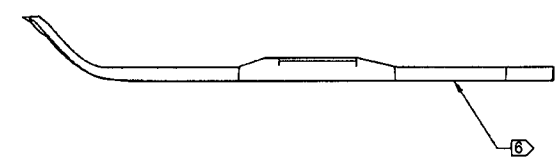
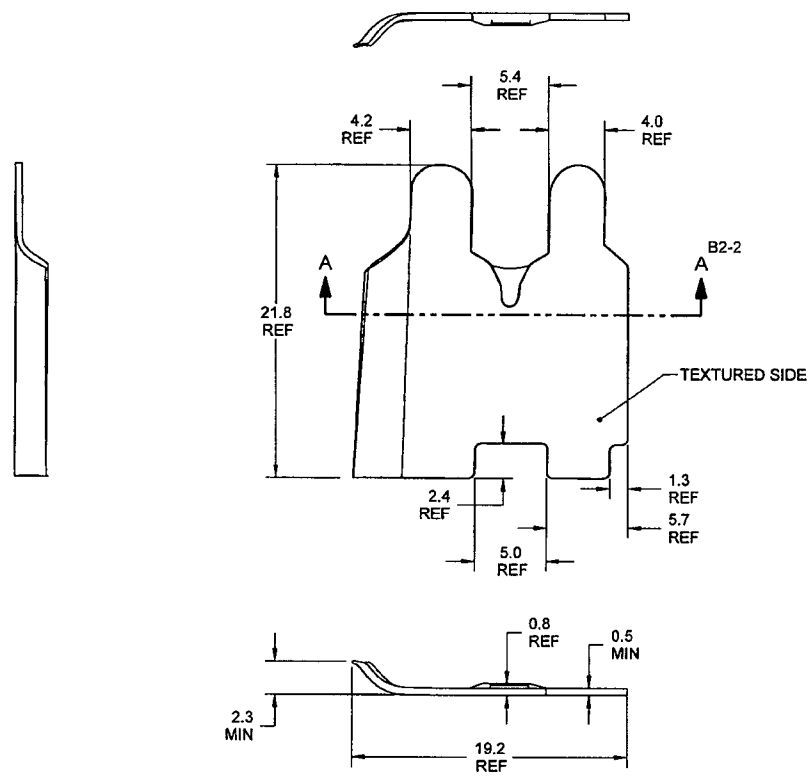
PROTOTYPE
09.04.21 #

REV	NEW ISSUE	DESCRIPTION	PH	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3874 TITLE FLOOR PROTECTOR <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			09.01.29
DRAWN	PH				
CHECKED					REV. A
MFG. APPR.					SHEET 1 OF 3
APPROVED					SCALE
DE APPR.					NTS
DATE	09.01.29				

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



SECTION A-A
SCALE 2X

D3874-1 FLOOR PROTECTOR

SUPERCEDED ON
09.04.22 RH

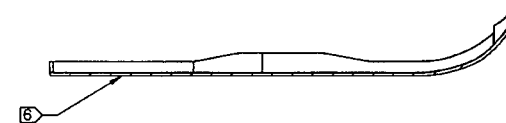
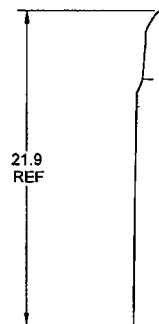
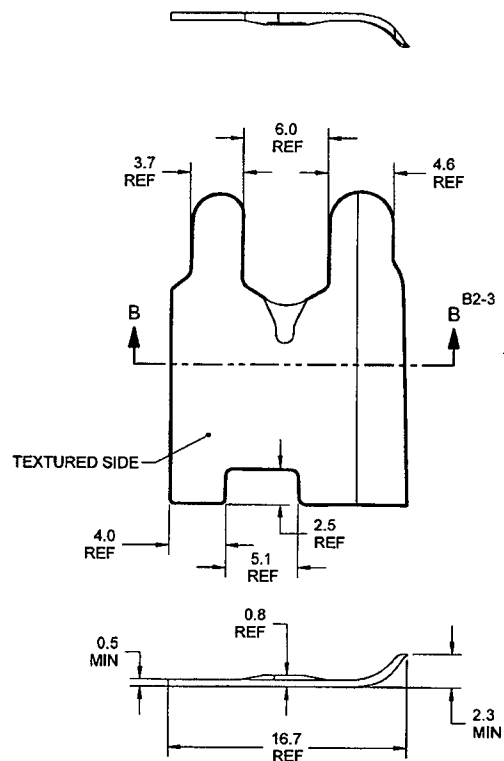
PROTOTYPE
04.09.21 RB

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3874	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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8 7 6 5 4 3 2 1



SECTION B-B
SCALE 2X

D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE

SUPERSEDED ON
09.04.22

PROTOTYPE

09.04.21

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3874	SHEET 3 OF 3
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DE APPR.		FLOOR PROTECTOR	NTS
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